Work Order ID 59200 -Page 1 Friday, May 28, 2010 9:17:21 AM Item ID: K10003 Accept Setup Start Revision ID: Item Name: Saddle, D205-634-011 Stop 5/27/2010 Start Date: Start Qty: Cust Item ID: Required Date: 6/4/2010 Req'd Qty: 0.00 Customer: Reference: Start Run Date: 10-5-2 Tooling: Process Plan: Approvals: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Reject Reject Accept Insp. Work Center ID Description **Run Hours** Qty Code Stamp Qty Number Draw Nbr Revision Nbr IIN634,635 Rev F 100 0.00 or BG 10/05/28 DOCUMENT CONTROL 0.00 Memo 8.0/02/31 Document Control Create White labels only per PPP K10003 CHG 007 110 Pick Kit 0.00 10-5-31 Packaging 0.00 Memo Packaging QC4- 100% Inspect kits for completeness

120

Quality Control

Memo

0.00

8 10/15/31

Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CH	IANGES					24
DATE	STEP	PRO	OCEDURE CHA	EDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	'Approval QC Inspector
		PAR #:			NCR: Yes No DQA: Date					
1	R	esolution:	Dispositio	n:	QA	: N/C CId	sed:		_ Date: _	
NCR:		'	WORK ORD	ER NON-CONFO	DRMANCE	(NCR)			
DATE STEP		Description of NC	Corrective Action		Section B		Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Descrip	ption	Sign & Date	Secti		Chief Eng	QC Inspector
		al all patrios								

Work Order ID 59200

Friday, May 28, 2010 9:17:21 AM



Page 2

Item ID:

K10003

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Saddle, D205-634-011

Required Date: 6/4/2010

5/27/2010 Start Oty: 10.00

Req'd Qty: 10.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

0.00

0.00

Set Up/ Tool ID Run Hours

Tool# Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/02 Hd P110-6-01

Dart Aerospace Ltd	D	art	Aeros	pace	Ltd
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W/O:			WO	RK ORDER CH	IANGES					
DATE	STEP	PRO	CEDURE CHAP	EDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									-4	
			PAR #: Fault Category: Disposition:							
	R	esolution:	Disposition	1:					Date:	
NCR:		,	WORK ORDE	ER NON-CONF	ORMANCE	(NCR)			
DATE	STEP	STEP Description of NC Section A		Corrective Action	Section B	Cian 9	Verific		Approval	Approval
			Initial Chief Eng	Action Descri Chief Eng		Sign & Date	Secti	Section C	Chief Eng	QC Inspector
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NOTE: D	ate & initi	al all entries								

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print Page 1 Friday, May 28, 2010 9:17:25 AM Work Order ID: 59200 Parent Item: K10003 Parent Item Name: Saddle, D205-634-011 Start Date: 5/27/2010 Required Date: 6/4/2010 Comments: IPP: I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF Start Qty: 10.00 Required Qty: 10.00 IPP: J 06-07-25 As per DSI 9344 JLM IPP: K 06.11.17 Per K10003 Rev C KJ IPP: L 07.01.12 Document Record for copying bluefile rmv KJ AN4-51A Purchased No 110 Each 136.0000 Location Loc Oty Loc Code ST361 136 112720 2 113121 34 114437 15 114495 85 Purchased No 110 Each 886.0000 16-5-31 Location Loc Qty Loc Code ST356 886 112933 96 113149 600 114523 114615 188 Purchased No 110 Each 77.0000 Location Loc Qty Loc Code ST361 77

114653

77

Dart /	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CH	IANGES					* .
DATE	STEP	PRO		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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		FV.)								
Part No	:	PAR #:	Fault Cate	egory:	NC	R: Yes	No DQ	A:	_ Date: _	
		esolution:								
NCR:		V	VORK ORD	ER NON-CONF	ORMANCE	(NCR)	. 5		
DATE STEP		Description of NC Corrective Action			Section B	Verificat			Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Descri Chief Eng	ption	Sign & Date	Secti		Chief Eng	QC Inspector
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Friday, May 28, 2010 9:17:25 AM

Work Order ID: 59200

Parent Item:

K10003

Parent Item Name:

Saddle, D205-634-011

Comments:

IPP: 1 □ 03.01.16 Reformat: Incorporated D205-641-011

IPP: J 06-07-25 As per DSI 9344

IPP: K 06.11.17 Per K10003 Rev C IPP: L 07.01.12 Document Record for copying bluefile rmv KJ

Start Date: 5/27/2010

Required Date: 6/4/2010

Start Qty: 10.00

Required Qty: 10.00

AN6-12A

Purchased

No

110

Each

166,0000

Loc Code



C	72	47	

112314 114523

KJ/RF

JLM

KJ

166 66 100

Loc Qty

110 Each

0.0000

M114376

Washer

AN960JD616

NAS1149D0663J Purchased

NAS1149D0463J Purchased

No

No

110 Each 0.0000

Each

MII 3584

Washer

D2570

Manufactured

110

238.0000

Loc Code

Bushing

Lie	жа	u	u	13
ST	01	8		

Loc Qty 238 38 200

Dart	Aeros	pace	Ltd
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W/O:			WC	RK ORDER CH	ANGES					
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval OC Inspector
									Prod Mgr	
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes No DQA:				_ Date: _	
	R	esolution:	Disposition	ı:	QA	: N/C Cld	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONF	ORMANCI	(NCR)			Pr 14
DATE	STEP Description of NC			Corrective Action	Section B		Verific	Verification	Approval Chief Eng	Approval
	SIEP	Section A	Initial Chief Eng	Action Descri Chief Eng	ption	Sign & Date	Section C			QC Inspector
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										1
										-32
NOTE: D	ate & initi	al all entries				1				

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Friday, May 28, 2010 9:17:25 AM

Page 3

Work Order ID: 59200

Parent Item:

K10003

Parent Item Name:

Saddle, D205-634-011

Comments:

IPP: I□ 03.01.16 Reformat: Incorporated D205-641-011

Manufactured

Manufactured

IPP: J 06-07-25 As per DSI 9344

IPP: K 06.11.17 Per K10003 Rev C

IPP: L 07.01.12 Document Record for copying bluefile rmy KJ



Start Date: 5/27/2010

Required Date: 6/4/2010

Start Qty: 10.00

Required Qty: 10.00

D2571



Manufactured

No

110

Each

19.0000

Loc Code

Loc Code



16-5-31

Saddle, Fwd In 205

Location Loc Qty ST425 43564 47564 ST433 58250 58667

KJ/RF

JLM

KJ

110

13.0000

Each

D2573



No

58100 58668

43565

Location

ST425

ST433

110

Loc Qty

Each 16.0000

Location Loc Oty Loc Code ST425 43566 47566 ST434 58251

Dart Aerospac	e Ltd	
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W/O:			WO	RK ORDER CHA	INGES					
DATE	STEP	P	PROCEDURE CHAP	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										the contract of
		PAR #:	Fault Categ	Fault Category: NCR: Yes No DQA: Disposition: QA: N/C Closed:				\:	Date:	
	Re	esolution:	Disposition	1:	QA: I	N/C Clo	sed:		_ Date: _	
NCR:		-	WORK ORDE	R NON-CONFOR	RMANCE	(NCR)			×	
DATE	STEP Description of NC			Corrective Action	Section B		Verific	ation	Approval	Approval
	SIEP	Section A	Initial Chief Eng	Action Descript	ion	Sign & Date	Section C		Chief Eng	QC Inspector
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Friday, May 28, 2010 9:17:25 AM

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Work Order ID: 59200

Parent Item:

K10003

Parent Item Name:

Saddle, D205-634-011

Comments:

IPP: 1 03.01.16 Reformat: Incorporated D205-641-011

IPP: J 06-07-25 As per DSI 9344

IPP: K 06.11.17 Per K10003 Rev C

KJ/RF

JLM

KJ

IPP: L 07.01.12 Document Record for copying bluefile rmv KJ

D2574

16 Saddle, Aft In 205

Manufactured No

No

110

110

110

Each

Loc Qty

12.0000



Start Date: 5/27/2010

Start Qty: 10.00

10-5-3

Required Date: 6/4/2010

Required Qty: 10.00

D2747 Set Screw

Location

ST425

ST434

Loc Code Each

105.0000

Loc Code

Loc Code

D2876 Saddle Spacer Manufactured No

Manufactured

Manufactured

Location ST023

39224

43567

58252

51921

Loc Oty 105

Loc Qty

89

42

4 101 Each

89.0000

Saddle Spacer

ST028

Location

42364 51540

51541

110

47 Each 84.0000

20

Location ST028

Loc Oty 84 21 63 Loc Code

58531 Shop Packet Print

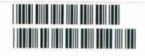
Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CH	ANGES					
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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										- 1
Part No	:	PAR #:	Fault Cat	egory:	NC	R: Yes	No DQ	A:	_ Date: _	
	R	Resolution: Disposition: QA: N/C Closed:					Date:			
NCR:		W	ORK ORE	DER NON-CONFO	DRMANCE	(NCR)			
DATE	CTED	Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descrip	otion	Sign & Date	Secti		Approval Chief Eng QC	QC Inspector
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		*					1			11
										-
									4	

Friday, May 28, 2010 9:17:25 AM

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Work Order ID: 59200 Parent Item: K10003



Parent Item Name:

Saddle, D205-634-011

Comments:

IPP: I□ 03.01.16 Reformat: Incorporated D205-641-011 IPP: J 06-07-25 As per DSI 9344

Manufactured

Manufactured

Manufactured

IPP: K 06.11.17 Per K10003 Rev C

KJ IPP: L 07.01.12 Document Record for copying bluefile rmv KJ

Start Date: 5/27/2010 Start Qty: 10.00

Required Date: 6/4/2010

Required Qty: 10.00

D3405-041



Manufactured No 110

Each

14.0000



10-5-314

Lug Assembly

D3405-043

Location ST474

No

No

No

56835 57726

KJ/RF

JLM

14 2 12 110 Each

Loc Qty

Loc Code

16.0000



Lug Assembly

Location ST474 53888 56574

Loc Qty 16 14 110 Each

13.0000

Loc Code

D3407-041



Location ST464

58209

52344

Loc Qtv 13

110

13

Each

Loc Code

45.0000

D3417-5 Washer

Location ST056

Loc Oty 45 45 Loc Code

Dart Aerospace Ltd	a	
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W/O:			V	ORK ORDER CH	IANGES					•••
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										P
Part No	:	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposit	ion:	QA	: N/C CId	sed:		Date:	1 - 2
NCR:		V	VORK OR	DER NON-CONF	ORMANCE	(NCR)			
DATE	STEP Description of NC		Initial	Section B				Approval	Approval	
		Section A	Chief Eng	Action Descri	puon	Date	Secti	on C	Chief Eng	QC Inspector
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Page 6

Work Order ID: 59200

Parent Item:

K10003

Parent Item Name:

Saddle, D205-634-011

Comments:

IPP: I□ 03.01.16 Reformat: Incorporated D205-641-011

IPP: J 06-07-25 As per DSI 9344

IPP: K 06.11.17 Per K10003 Rev C

IPP: L 07.01.12 Document Record for copying bluefile rmv KJ

KJ/RF

JLM

KJ

D3456-1

Manufactured No 110

110

110

Each

129.0000

Loc Code



Start Date: 5/27/2010

Start Qty: 10.00

10-5-31

Required Date: 6/4/2010

Required Qty: 10.00

4 Washer

Manufactured

Purchased

Location

ST058

No

No

Loc Qty

129 129

Each

119,0000

6

Set Screw

Location

ST069

51602

Loc Qty 119

119

Each

4,601.000

Loc Code

240

16-5-31 5

MS21042L4

Location ST139

ST300

111827

113422 114523

114718 114784 9063

Loc Qty 2

1000 2000 8

Loc Code

Dart Aerospace Ltd

W/O:			W	ORK ORDER CH	HANGES					* ; ,
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										5
										-
Part No	:	PAR #:	Fault Cate	egory:	NC	R: Yes	No DQ	A:	Date:	
	R	esolution:	Disposition	on:	QA	: N/C Cld	sed:		_ Date: _	
NCR:		V	WORK ORD	ER NON-CONF	ORMANCE	(NCR)			
DATE	STEP	Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Descri Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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Friday, May 28, 2010 9:17:25 AM

Page 7

Work Order ID: 59200

Parent Item:

K10003

Parent Item Name:

Saddle, D205-634-011

Comments:

IPP: I□ 03.01.16 Reformat: Incorporated D205-641-011

IPP: J 06-07-25 As per DSI 9344

IPP: K 06.11.17 Per K10003 Rev C

IPP: L 07.01.12 Document Record for copying bluefile rmv KJ

Start Date: 5/27/2010

Start Qty: 10.00

Required Date: 6/4/2010

Required Qty: 10.00

MS21043-4

Purchased

No

110

KJ/RF

JLM

KJ

Each

1,628.000



6x)\$

A Nut

Location	Loc Qty	Loc Code	
FG	40		
104603	40		
ST301	1588		
112492	25		
113069	8		
114181	255		
114348	500		
114523	500		
114784	300		

Dart Aeros	pace Ltd	
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W/O:			W	ORK ORDER CH	HANGES					* * .
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	tegory:	NC	R: Yes	No DQA	A:	Date:	
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NCR:		\	WORK ORI	DER NON-CONF	ORMANCE	(NCF	R)			8. "
DATE	STEP	Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval
DAIL	SILI	Section A	Initial Chief Eng	Action Descri Chief Eng	ption	Sign & Date	Section		Chief Eng	QC Inspector
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REFERENCE ONLY

D205-634 . Page 10 of 10





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	1	Х				D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
	1					D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	13.11		Х			D205-634-041	SKIDTUBE
		1		Х		D205-634-045	SKIDTUBE
	1	1			Х	D205-641-011	GROUND HANDLING KIT
			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1	- 12			1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3	1		1	1		D2855	* AFT CAP
4	111		2	2		AN3-5A	* BOLT
5			2	2		AN960JD10L	* WASHER
6A			1	1		D3564-9	*WEARSHOE (REPLACES D2577-1)
6B	CONT		1	1		D3566-1	* GASKET
7A -	J.		1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B	1450		1	1		D3566-1	* GASKET
8A	1315		1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B	111		1	1		D3566-5	* GASKET
9A	Y-50-7		1	1		D3564-13	* WEARSHOE
9B	ALI.		1	1		D3566-13	* GASKET
10	HE.		50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11	100		50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572 /	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8		90		AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				AN960JD616	WASHER
29	16	16				AN4-6A	BOLT
30	32	32				AN960JD416	WASHER
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4		_		D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D3407-041	TOW RING (REPLACES D2968-041)
41	1	1				D3456-1	WASHER
43	1					MS21043-4	NUT
44	2	2				D3417-5	WASHER
50				1.1	1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51	-			110	1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52		6		7.45	4	AN4C47A	BOLT
53	UGH	7		7	8	D2570	BUSHING
54					4	MS21043-4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: F

Date: 08.10.07

Dart Aerospace Ltd

		V	VORK ORDER CH	IANGES					
STEP	PROCI	EDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							2		
									9 -
				R : }_				11	
:	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQ	A:	_ Date: _	1
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OTED	Description of NC		Corrective Action	Section B		Verific	ification	Approval	Approval
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	STEP	:PAR #: Resolution:W(STEP PAR #: Fault Ca Resolution: Disposit WORK OR STEP Description of NC Section A Initial Chief Eng	STEP PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFO STEP Description of NC	PAR #: Fault Category: NC Resolution: Disposition: QA WORK ORDER NON-CONFORMANCI STEP Description of NC	STEP PAR #: Fault Category: NCR: Yes I Resolution: Disposition: QA: N/C Clo WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Corrective Action Section B Chief Eng	STEP PAR #: Fault Category: NCR: Yes No DQ. Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Corrective Action Section B Section A Chief Eng Chief	STEP PAR #: Fault Category: NCR: Yes No DQA: Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Corrective Action Section B Sign & Date Chief Eng C	STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng Crow Mgr. PAR #: Fault Category: NCR: Yes No DQA: Date: Disposition: QA: N/C Closed: Date: